



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.3110

Job Sheet 186240



Part No: 646.3110

Job Qty: 24 ea

Part Name: Channel



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/13/18

Job Tracking No:

Due Date: 11/28/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG 646.3100 REV N/C IPP REV:A NEW ISSUE 12-10-24 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	24 Ea	11/28/18	11/28/18	0.00	0.00	Start Up Machining-1		U48 19/12/15
100	Bandsaw	24 pcs	11/28/18	11/28/18	0.00	1.32	Bandsaw1		SBL 19/02/16
110	CNC Vertical Machining	24 pcs	11/28/18	11/28/18	0.43	26.67	HAAS1-1		SBL 19/02/17
120	QC	24 pcs	11/28/18	11/28/18	0.00	0.00	QC2 Machining-1		SBL 19/02/17
130	QC	24 pcs	11/28/18	11/28/18	0.00	0.00	QC8 Machining-1		KT 19-02-20
140	Outsource	24 pcs	11/28/18	11/28/18			ATG001-VC	8	GTA-2-20
150	Packaging	24 pcs	11/28/18	11/28/18	0.00	0.00	Packaging2		MAR 11 2019
155	QC	24 pcs	11/28/18	11/28/18	0.00	0.00	QC5		MAR 13 2019
180	Packaging	24 pcs	11/28/18	11/28/18	0.00	0.00	Packaging3-1		MAR 13 2019
190	QC21-SA	24 Ea	11/28/18	11/28/18	0.00	0.00	QC21		MAR 13 2019

Part Op 100 - Cut Blank at 15.00"

Descriptions: 110 - 1-Machine per folio FB145

140 - Issue P/O to ATG - Hard Anodize Black and Prime as per Dwg 646.3100

180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6S1.500X1.500	7075-T6S Sheet 1.5" Thick Plate X 1.5" Wide	30 ft (1.25 ea)	90-Start up Operation	5138087

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M7075T6S1.500X1.500	30	4	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Channel	14.600inches ± 0.010	14.610 14.590		14.595
2	Channel	13.130inches ± 0.010	13.140 13.120		13.125
3	Channel	0.090inches ± 0.010	0.100 0.080		1.090
4	Channel	0.470inches ± 0.010	0.480		1.470

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

			0.460	
5	Channel	0.750inches ± 0.010	0.760 0.740	,750
6	Channel	83.000Degrees ± 0.500	83.500 82.500	Angle 83,00
7	Channel	0.880inches ± 0.010	0.890 0.870	,875
8	Channel	0.645inches ± 0.005	0.650 0.640	,646
9	Channel	0.110inches ± 0.010	0.120 0.100	,110
10	Channel	0.120inches ± 0.010	0.130 0.110	,115
11	Channel	0.209inches + 0.005 - 0.001	0.214 0.208	Diameter ,210
12	Channel	0.409inches ± 0.005	0.414 0.404	,410
13	Channel	0.420inches ± 0.002	0.422 0.418	,419
14	Channel	2.188inches ± 0.002	2.190 2.186	,2,188
15	Channel	2.188inches ± 0.002	2.190 2.186	,2,188
16	Channel	2.188inches ± 0.002	2.190 2.186	,2,188
17	Channel	2.187inches ± 0.002	2.189 2.185	,2,188
18	Channel	0.785inches ± 0.002	0.787 0.783	,785
19	Channel	2.395inches ± 0.002	2.397 2.393	,2,395
20	Channel	0.669inches ± 0.002	0.671 0.667	,669
21	Channel	0.372inches ± 0.002	0.374 0.370	,372
22	Channel	0.334inches ± 0.002	0.336 0.332	,333
23	Channel	0.175inches ± 0.002	0.177 0.173	,173
24	Channel	0.130inches ± 0.002	0.132 0.128	,129

Plex 11/13/18 10:33 AM Dart.lajeunesse.marie



Container No: S154342



Part: 646.3110

Job No: 186240

Serial No/Batch: S154342

Revision:

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 02/15/19

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042670



Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalonde, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO042670

PO Date: 2/20/19

Due Date: 3/6/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	189248	RBE350A93-3302-02-5	Extension Handle -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	3/6/19	10 pcs	0 pcs	10 pcs	\$5.76/pcs	\$57.60
2	186507	D5574-1	Blade Housing, Cable Cutter : Various STC's Issue P/O to ATG : Black Anodize & Prime as per Dwg. D5574 Certification of Conformity is required.	Firmed	-	3/6/19	6 pcs	0 pcs	6 pcs	\$11.55/pcs	\$69.30



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042670



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	189540	C3-8-5	Solenoid Cover Outsource process-Anodize per QSI017 4.1.10.1) -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL-A- 8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	3/6/19	10 pcs	0 pcs	10 pcs	\$5.76/pcs	\$57.60
4	186240	646.3110	Channel Issue P/O to ATG 1- Hard Anodize Black and Prime as per Dwg 646.3100	Firmed	-	3/6/19	24 pcs	0 pcs	24 pcs	\$12.00/pcs	\$288.00
5	188674	RB DB3225L-5	Hose End Outsource process-Anodize per QSI017 4.1.10.1 -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A- 8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed	-	3/6/19	17 pcs	0 pcs	17 pcs	\$6.30/pcs	\$107.10
	189121			Firmed	-	3/6/19	8 pcs	0 pcs	8 pcs	\$6.30/pcs	\$50.40
Sub Total:							25	0	25		\$157.50
6	188306	646.3714	Gusset Issue P/O to ATG Hard Anodize, Color Black and Prime as per Dwg 646.3700 Rev. A	Firmed	-	3/6/19	21 pcs	0 pcs	21 pcs	\$17.05/pcs	\$358.05



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042670



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
7	188703	RBE105-14181W1-9	Drift -Issue P/O; -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	3/6/19	4 pcs	0 pcs	4 pcs	\$5.76/pcs	\$23.04
4X FEB 27 2019											
Line Item Note Need for the 26											
8	188704	RBE105-14181W3-1	Support -Issue P/O; -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	3/6/19	4 pcs	0 pcs	4 pcs	\$5.76/pcs	\$23.04
4X FEB 27 2019											
Line Item Note Need for the 26											
9	186710	646.3210	Support Issue P/O to ATG 1- Hard Anodize Color Black and Prime as per Dwg 646.3200	Firmed	-	3/6/19	12 pcs	0 pcs	12 pcs	\$15.65/pcs	\$187.80
Grand Total:										\$1,221.93	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042670



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 2/27/19 10:47 AM dart.tsimiklis.chrisoula



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 917404

Date: 08-Mar-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
✓ 6 ea	Part: D5574-1 Blade Housing, Cable Cutter Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 24651	Rev: A PO: PO042670	Line: 2
✓ 24 ea	Part: 646.3110 Channel Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 24676	Rev: NC PO: PO042670	Line: 4
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>MAR 08 2019</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt. Made in Canada.			